

Date: Tuesday, 12/12/2006 9:09:03 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : INITIAL PROTOTYPE TEMPLATE
Job Number : 00095A	
Estimate Number : 10068	
P.O. Number :	Part Number : INITIAL PROTOTYPE
This Issue : 12/12/2006 S.O. No. :	Drawing Number :
Prsht Rev. : NC	Project Number : ES0001
First Issue : 11/23/2006 Type : R&D GENERAL	Drawing Revision :
Previous Run : 00094A	Material :
Written By : <u>SLM 06-11-24</u>	Due Date : 11/30/2006 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Project #: D212-725 EAGLE "S"	
Description: VARIOUS TUBINGS	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TR1000W049	304 RD Tube 1.0" x .049W
-----	----------------	--------------------------



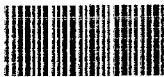
Comment: Qty.: 6.5000 f(s)/Unit Total : 6.5000 f(s) (D212-725-1-905)

304 RD Tube 1.0" x .049W

Batch: M19448

SB 06/12/11 (2)

2.0	MS2081916J	Sleeve
-----	------------	--------



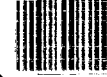
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) (D212-725-1-905)

Sleeve

Batch: M1260

SB 06/12/11 (2)

3.0	AN81816J	Nut
-----	----------	-----



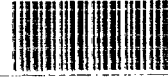
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) (D212-725-1-905)

Nut

Batch: M1256

SB 06/12/11 (2)

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form d212-725-1-905 tube Assembly as per Dwg D212-725-1

2-Flare as per Dwg D212-725-1

Identify as D212-725-1-905

SB 06/12/11 (2)

2

Labrate D212-725-1-029 as per ~~Fig~~ Eagle template.

AD 06-12-11

1 piece was scrap flaring neck

scrap + destroy
+ replace

SB 06/12/14

Date: Tuesday, 12/12/2006 9:09:03 AM
User: Jean-Luc Menard

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INITIAL PROTOTYPE TEMPLATE

Job Number: 00095A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PC 06.12.11

6.0

M304TR0375W035

304 TUBING



Comment: Qty.: 3.5000 f(s)/Unit Total : 3.5000 f(s) (D212-725-1-917)

304 TUBING

Batch: M18993

SB 06/11/27 2

7.0

AN8186J

nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) (D212-725-1-917)

NUT

BATCH: M102850

8.0

MS208196J

sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

sleeve

Batch: M102850

(D212-725-1-917)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form d212-725-1-917 tube Assembly as per Dwg D212-725-1

2-Flare ends as per Dwg.

Identify as D212-725-1-917

SB 06/11/27 ②

SB 06/12/12 ②

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PC 06.12.11

11.0

M304TR0625W035

304 RD Tube .625 x .035W



Comment: Qty.: 1.5000 (s)/Unit Total : 1.5000 (s) (D212-725-1-903)

304 RD Tube .625 x .035W

Batch: M102958

SB 06/12/13 ②

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INITIAL PROTOTYPE TEMPLATE

Job Number: 00095A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS2081910J

sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) (D212-725-1-903)

sleeve

Batch: M 102850

SB 06/12/14

(1)

13.0

AN81810J

nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) (D212-725-1-903)

nut

Batch: M 102850

SB 06/12/14

(2)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form d212-725-1-903 tube Assembly as per Dwg D212-725-1

2-Flare ends and assemble as per Dwg.

Identify as D212-725-1-903

SB 06/12/14

(2)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06.12.14

(2)

16.0

M6061T6T1500W125

6061T6 TUBE 1.500X .125W



Comment: Qty.: 1.5000 f(s)/Unit Total : 1.5000 f(s) (D212-725-1-025)

6061T6 TUBE 1.500X .125W

Batch: M18639

-027

SB 06.12.14

(2+2)

17.0

LATHE CONV.

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE

Turn ID as per Dwg D212-725-1 FOR -025/-027

SB 06.12.14

(2+2)

18.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(-025-027)

SB 06.12.14

(2+2)

Date: Tuesday, 12/12/2006 9:09:03 AM
User: Jean-Luc Menard

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INITIAL PROTOTYPE TEMPLATE

Job Number: 00095A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC8

SECOND CHECK



Comment: SECOND CHECK

EC 06.12.14

Job Completion

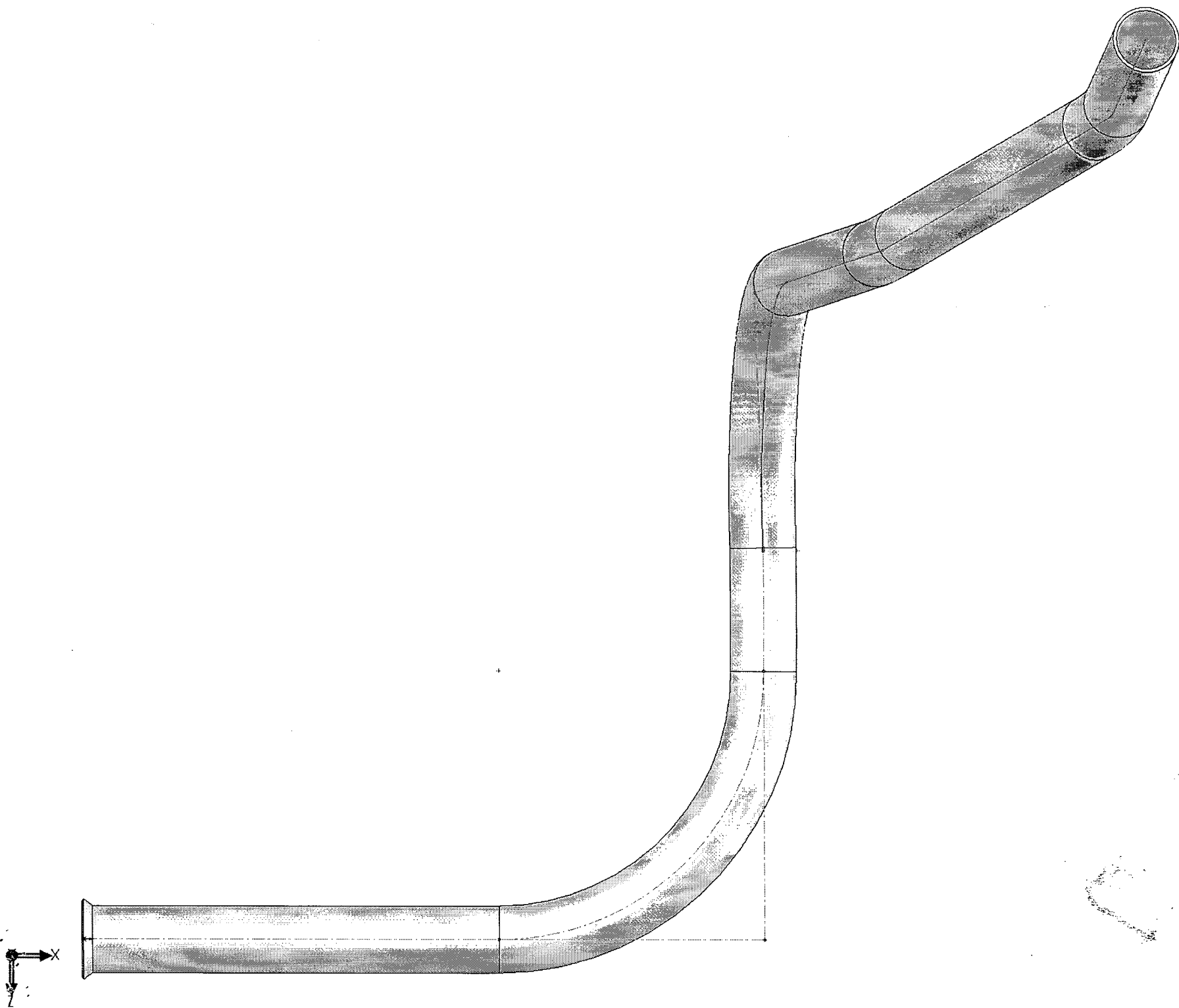


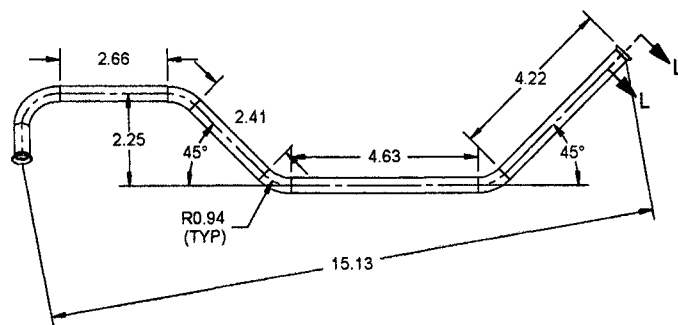
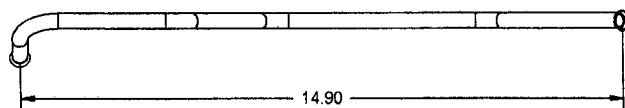
ENGINEERING PROJECT MANAGER

APPROVAL *H 06.12.11*

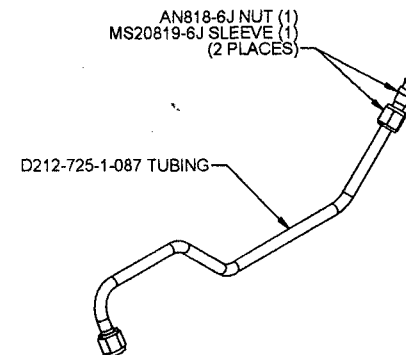
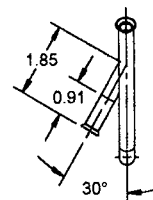
LEVEL 21 INSPECTION

HA 06.12.22

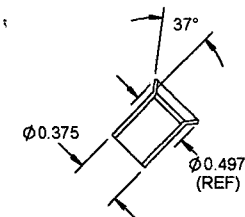




D212-725-1-087 TUBING
MANUFACTURE PER TEMPLATE DT8910



D212-725-1-917 TUBE ASSEMBLY

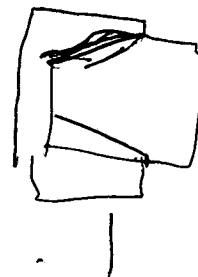


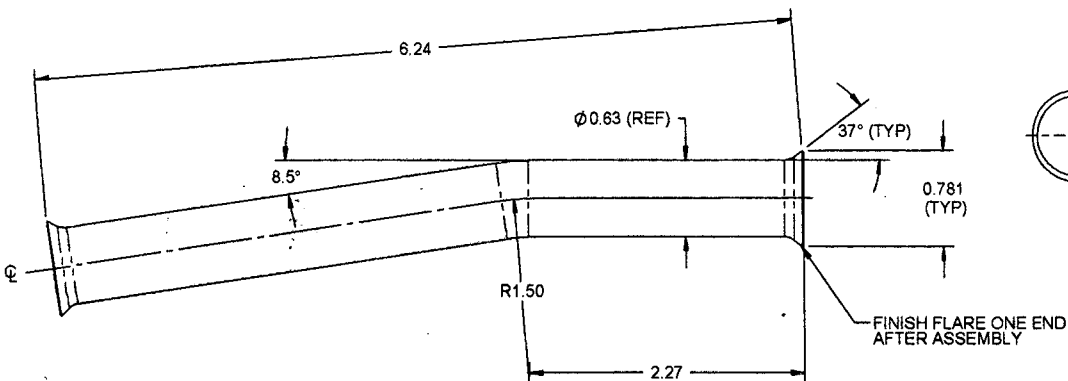
SECTION L-L
(FINISH FLARE ONE END
AFTER ASSEMBLY)
SCALE 1 : 1

NOTES:

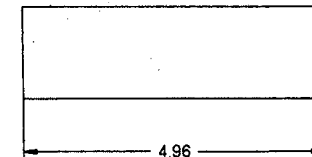
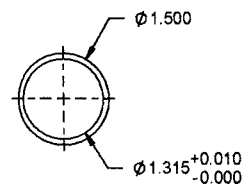
- 1) MATERIAL: AISI 304/316 SS Ø0.375 x 0.035 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.375W.035)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D212-725-1-917 USING FINE POINT PERMANENT INK MARKER

DESIGN DC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A SHEET 34 OF 38
DATE 06.10.27		TITLE 212S DETAIL PARTS	SCALE 1:3
COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

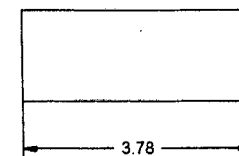
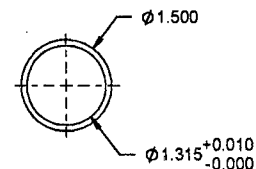




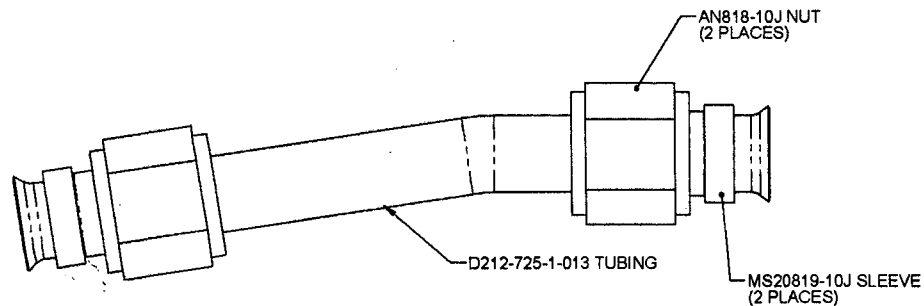
D212-725-1-013 TUBING
MANUFACTURE PER TEMPLATE DT8906



D212-725-1-025 SPACER
SCALE 1:2



D212-725-1-027 SPACER
SCALE 1:2



D212-725-1-903 TUBE ASSEMBLY

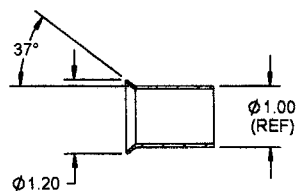
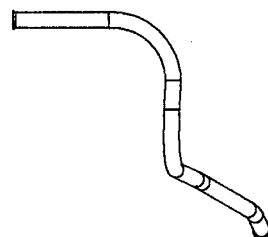
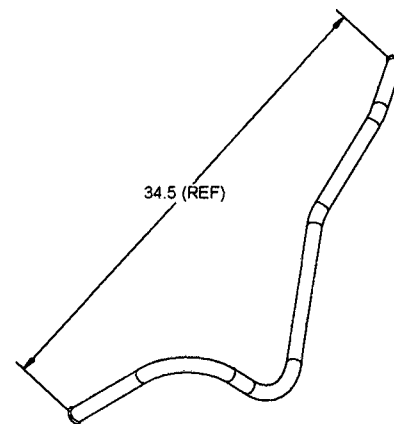
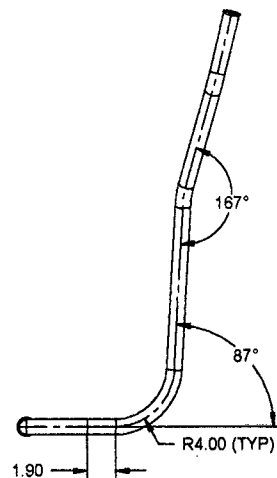
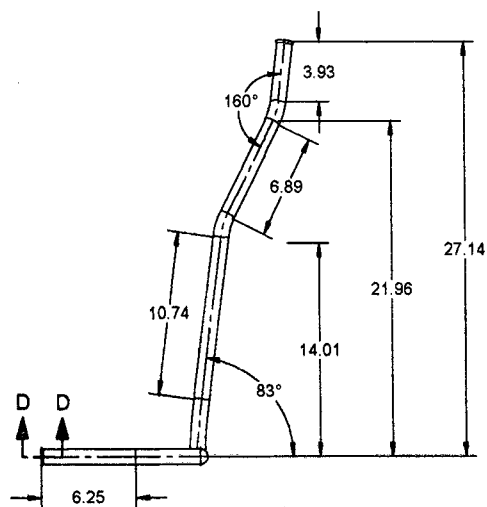
D212-725-1-025-027 NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM (REF. DART SPEC. M6061TX.XXXW.XXX OR M6061T6R)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

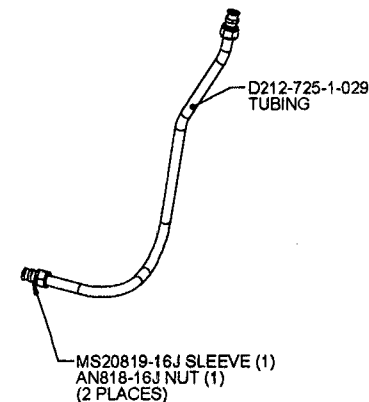
D212-725-1-013 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBING 0.625 O.D. x 0.020 WALL (REF. DART SPEC. M304TR0.625W0.020)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN DC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A SHEET 6 OF 36
DATE 06.10.27		TITLE 212S DETAIL PARTS	SCALE 1:1
COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



SECTION D-D
(FINISH FLARE ONE END
AFTER ASSEMBLY)
SCALE 1:2
(2 PLACES)



D212-725-1-905 TUBE ASSEMBLY

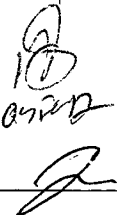
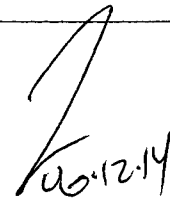
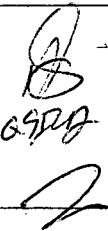
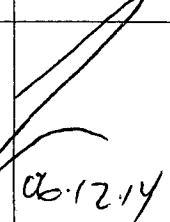
D212-725-1-029 TUBING MANUFACTURE PER TEMPLATE DT8907

NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL 1.00 O.D. x 0.049 WALL (REF. DART SPEC. M304TR1.000W.049)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY ASSEMBLY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN DC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A SHEET 10 OF 38
DATE 06.11.20	TITLE 212S DETAIL PARTS		SCALE 1:8
COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/12/14	14	1 piece flaring crack	 06/12/14	Scrap - destroy replace it	SB 06/12/14	 06.12.14	 06/12/14	 06.12.14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

